

Date: Monday, 2/11/2008 2:15:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 37370		
Estimate Number	: 11162		
P.O. Number	:	Part Number	: D32641
This Issue	: 2/11/2008 S.O. No. :	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35133	Material	:
Written By	:	Due Date	: 2/27/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JA 08 02 11</u>		
Comment	: Est A 04.09.02 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty: 0.5097 f(s)/Unit Total: 6.1160 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B1.250x04.500)  
 Identify for D3264-1  
 Batch: 105531

JA 08/02/20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

JA 08/02/20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA447 and Dwg D3264  
 Identify as D3264-1  
 Deburr

HA 08/03/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 08/03/11

5.0	QC8	SECOND CHECK
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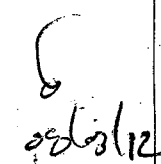
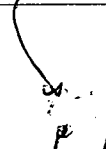
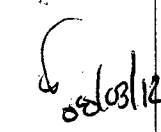

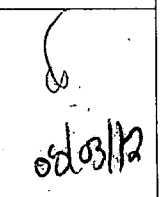
Comment: SECOND CHECK

JA 08/03/12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Prod / Machine <sup>Part 5</sup> NCR: Yes No DQA: Y Date: 08/03/19  
 QA: N/C Closed: Y Date: 08/03/19

NCR: <u>37370</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/12	3.0	Bottom floor thickness too thin of .001" to .007" 0.125 is 0.111 and 0.112 3 ports, one at 0.108	LE 08-03-12	Acceptable. Margin of safety is 0.2 part @ 0.108 has MS=0.16	H.A 08/03/12		LE 08-03-12	
08/03/12	3.0	The vise was too tight.	↓	↓	H.A 08/03/12		↓	
08/03/10	3.0	Dart crest not centered	↓	↓	H.A 08/03/12		↓	

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:15:08 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37370

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l

08/03/13

7.0

POWDER COATING

POWDER COATING



(12x)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

08/03/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



44

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-14

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 164

8/3/11

54

(12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/03/19

Job Completion



m 2008/3/18

(12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37370
<b>Description: Bracket</b>		<b>Part Number:</b>	D3264-1
<b>Inspection Dwg: D3264 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.690	✓			
0.063	+/-0.010	.063	✓			
0.125	+/-0.010	.119	✓			
0.875	+0.010/-0.020	.871	✓			
0.062	+/-0.010	.063	✓			
R0.03	+/-0.030	r.03	✓			
R0.13	+/-0.030	r.130	✓			
1.00	+/-0.030	.999	✓			
0.125	+/-0.010	.124	✓			
0.600	+/-0.010	0.600	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.7477	✓			
Ø0.194	+0.005/-0.000	0.1955	✓			
5.50	+/-0.030	4.499	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.063	✓			
R0.25	+/-0.030	r.25	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	r.30	✓			

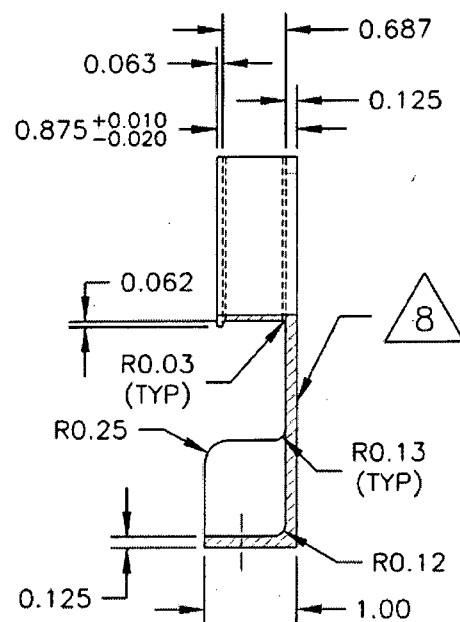
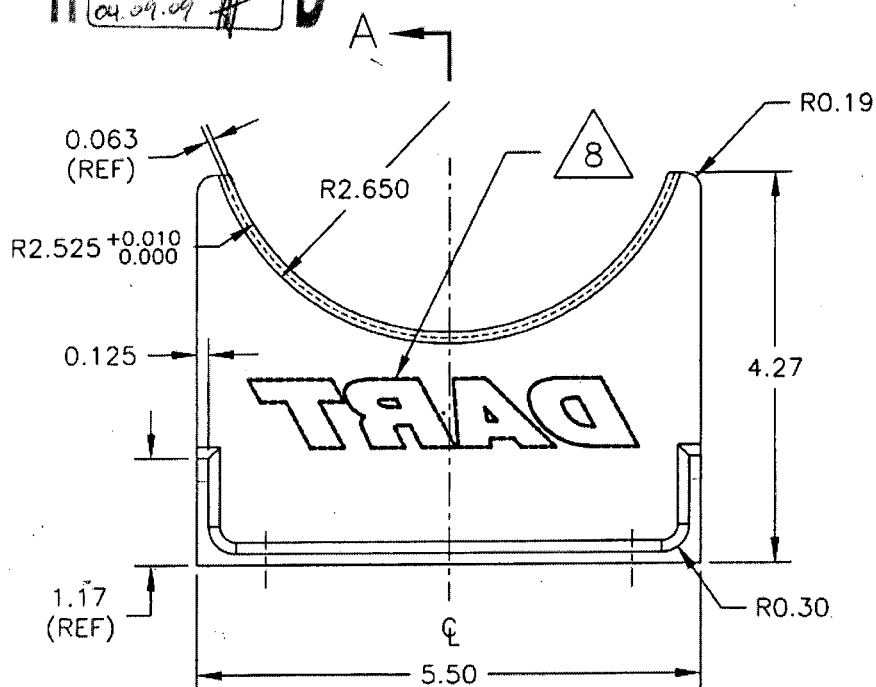
<b>Measured by:</b>	J.L	<b>Audited by:</b>	Amf	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	08/03/10	<b>Date:</b>	08/03/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

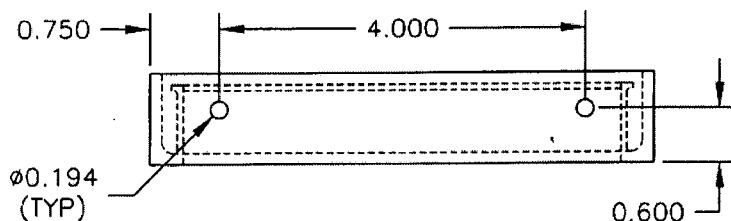


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.04.09 H



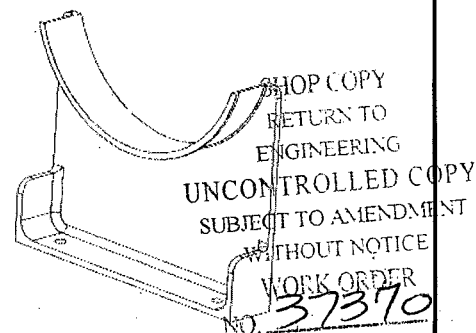
SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25



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